W	arl	zΩ	rder	ID	53968	2
vv	UI F	<b>、</b> 、	T CICL	117	- 33700	,

Quality Control

Memo



Page 1

November 24, 2009 11:16:33 AM D2873-045 Accept Item ID: Setup Start **Revision ID:** Α Stop Item Name: Nut Plate Assembly Start Qty: 20.00 **Start Date:** 25/11/2009 **Cust Item ID:** Required Date: 07/12/2009 Req'd Qty: 20.00 **Customer:** Reference: Run Start Date/92/1-24 Tooling: Process Plan: Date: Approvals: Stop SPC (Y/N): Date: Date: QC: Reject Reject Draw Plan Insp. Sequence ID/ Operation Set Up/ Draw Accept Stamp Qty Qty Number **Work Center ID Description Run Hours** Number Rev. Code Draw Nbr **Revision Nbr** D2873 Rev A 0.00 100 BAND SAW ml oglil27 Bandsaw Memo Cut blanks: 1.000" x 0.375" x 2.700" long Jeaspa Bandsaw 0.00 110 HAAS CNC VERTICAL MACHINING #1 Memo Machine as per Folio FA and Dwg D2873 □ Identify as D2873 HAAS CNC vertical machine #1 F1819Folio Rev A Dwg Rev A QC2- Inspect parts off machine FAI/FAIB 120

Dart Aerospa	ace Ltd
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W/O:			ORK ORDER CHANG	ES				, <b>8</b> 1					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date (	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	•	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQA:		_ Date:					
	R	esolution:	Disposit	ion:	_ QA: N/C Cld	sed:		_ Date: _					
NCR:			WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC		Corrective Action Section		Verification Approx			Approval				
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	С	Chief Eng	QC Inspector				
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#### Work Order ID 53968 November 24, 2009 11:16:33 AM



Page 2

Item ID:

D2873-045

Accept

Setup Start

Stop

Revision ID:

Α Item Name: Nut Plate Assembly

**Start Date:** 

25/11/2009

Start Qty: 20.00

**Cust Item ID:** 

**Customer:** 

Draw

Number

**Required Date: 07/12/2009** 

Req'd Qty: 20.00

Reference:

Process Plan:

Date:

Tooling:

Date:

Draw

Rev.

Run Start

Reject

Qty



Reject

Number

Approvals:

QC: Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Stop

Insp. Stamp

Sequence ID/ **Work Center ID** 

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

0.00

0.00

S\$ 09/11/24

Accept

Qty

Plan

Code

20

140

Small Fab

Small Fab

Memo

Memo

0.00

0.00

Small Fab

1-Deburr □2- C'sink as per Dwg D2873

6509/11/30 @

150

Quality Control

QC5- Inspect part completeness to step on W/O

2) Sorlul 30

# **Dart Aerospace Ltd**

W/O:			iES		<del></del>									
DATE	STEP	PRO	CEDURE CH	ANGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR:	Yes I	No <b>DQ</b>	A:	Date:					
	Resolution: Disposition:													
NCR:		\	WORK ORI	DER NON-CONFORMA	ANCE (	NCR	)							
DATE	STEP	Description of NC	Corrective Action Section B			Verit			Approval	Approval				
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector				
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#### Work Order ID 53968

November 24, 2009 11:16:33 AM



Page 3

Item ID:

D2873-045

Accept

Setup Start

Revision ID:

Α Item Name: Nut Plate Assembly

Stop

Start Date:

25/11/2009

**Start Oty: 20.00** 

**Cust Item ID:** 

**Required Date: 07/12/2009** 

Rea'd Otv: 20.00

**Customer:** 

Reference:

Process Plan:

Date:

Tooling:

Date:

Draw

Start

Approvals:

OC:

SPC (Y/N): Date:

Date:

Stop

Sequence ID/ Work Center ID

160

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per OSI005 4.1

Set Up/ **Run Hours** 

Number Rev.

Draw

Plan Code

Reject Accept Qty Qty

Run

Reject Number

Insp. Stamp

Memo

09/12/01

170

OC

Quality Control

OC3- Inspect Part Finish

Memo

X 09-12-1

180

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

## **Dart Aerospace Ltd**

W/O:		-	WO	RK ORDER CHANG	SES	<u> </u>								
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
•	;													
		-												
Part No	:	PAR #:	Fault Categ	jory:	NCR: Ye	s No <b>DQ</b>	A:	Date:						
Resolution:			Disposition	1:	QA: N/C	Closed:		Date: _						
NCR:		•	WORK ORDER NON-CONFORMANCE (NCR)											
DATE	STEP	Description of NC			tion B	Verific	cation	Approval	Approval					
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat		ion C	Chief Eng	QC Inspector					
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#### Work Order ID 53968

November 24, 2009 11:16:33 AM



Page 4

Item ID:

D2873-045

25/11/2009

Accept

Setup Start



Item Name:

Revision ID: Α

Nut Plate Assembly

Start Ofv: 20.00

Cust Item ID:

Customer:

Stop

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start



**Required Date: 07/12/2009** 

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/ Work Center ID

190

**Ouality Control** 

Operation Description

Reg'd Oty: 20.00

OC5- Inspect part completeness to step on W/O

**Run Hours** 

2) Sorliela 0.00

Draw Number Draw Plan Rev. Code Accept Oty

Reject **Qty** 

Reject Insp. Number Stamp

countro

Run

200

Packaging

Packaging

Identify as per dwg & Stock Location: X-1025

Memo

Memo

0.00

0.00

210

OC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

Dart Aeros	pace Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·· ,						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	Re	esolution:	Dispositio	n:	QA: N/C C	losed:		Date:	· · · · · · · · · · · · · · · · · · ·
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)	13.07.		···
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Description	tion B		ication Approval		Approval QC Inspector
		Section A	Chief Eng	Chief Eng	Date		on C	Chief Eng	uc inspector
·									

#### **Picklist Print**

Comments:

November 24, 2009 11:16:40 AM

Work Order ID: 53968

D2873-045RevA Parent Item:

Parent Item Name: Nut Plate Assembly

THE REPORT OF THE PROPERTY OF

Start Date: 25/11/2009

**Required Date: 07/12/2009** 

Page 1

**Start Qty: 20.00** 

Required Qty: 20.00

									- •			
Component Item ID/ Item Name	Replacement Item ID	Mfg/	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21075L5	11H1H 111 1H1 1H1	Purchased	No			100	Each	410.0000	40.0000	B09/1	2/01	
				Wareho	use	Loc	Qty	Loc Code				
				Loc	ation							
				Main W	arehouse						•	
				ST			410					
					110916		79		_	· · · · · · · · · · · · · · · · · · ·		
					112243		331			10		
M6061T6B0.375X01.00		Purchased	No			180	f	17.6095	4.7368			
0 6061T6 BAR .375 x 1.00												
				Wareho	ouse	Loc	<u>Qty</u>	Loc Code				
				Loc	ation							
				Main W	arehouse							*

Main Warehouse MAT 17.60947368 105225 5.3 →110829 12.3094737

4.2368 mf oglul27

Dart Aerospace L	td
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W/O:						······			
DATE	STEP	PROC	EDURE CH	ANGE		Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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					A Committee of the Comm				
			u-100						
Part No	•	PAR #:	egory:	_ NCR	: Yes N	lo DQA:_	Date:		
	R	esolution:	Disposition	on:	_ QA:	N/C Clo	sed:	Date:	
NCR:		W	ORK ORE	ER NON-CONFORMA	NCE	(NCR)	,		
DATE	STEP	Description of NC		Corrective Action Section B			Verification	on Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		QC Inspector
						772			

#### **Picklist Print**

November 24, 2009 11:16:40 AM

Work Order ID: 53968

Parent Item:

D2873-045RevA

Parent Item Name: Nut Plate Assembly

Comments:



Start Date: 25/11/2009

**Required Date: 07/12/2009** 

Page 2

**Start Qty: 20.00** 

Required Qty: 20.00

Component Item ID/	Replacement	Mfg/	Bin Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
MS20426AD4-6		Purchased	No	,	180	Each	3,930.000	80.0000	JS09	/12/01	

Rivet

Warehouse Location	Loc Oty	Loc Code	
Main Warehouse			
ST	3930		
100151	27		<u> </u>
103395	14	1 .	
105144	88		
110139	3774	•	<u>¥3</u>
2525	27		<u> </u>

## **Dart Aerospace Ltd**

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	By Date Oty Chief Fog / Approval			Approval QC Inspector
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'									
Dort No		DAD #	Fault Cate		NCD: Voc	No BOA		Dete	<del>                                     </del>
Part No: PAR #:						•			
Resolution:			Disposition: QA: N/C Closed: Date:						
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE (NC	₹)		***************************************	
DATE	STEP	Description of NC	Corrective Action Section B			Verification App		Approval	oval Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		Section C		QC Inspector
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DART AEROSPACE LTD	Work Order:	53968
Description: Radius Block	Part Number:	D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

	X Fi	rst Article	Pr	ototype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.501	<b>V</b>			
1.000	+/-0.010	0.999	V			
0.750	+/-0.010	0.750	>			
0.250	+/-0.010	0.250	1			
1.000	+/-0.010	1.000	/	:		
2.000	+/-0.010	2.000	/			
Ø0.128	+0.005/-0.001	Ø0.131	<b>/</b>			
0.359	+/-0.010	0.359	レ			
Ø0.316	Ø0.316 +0.006/-0.001		<b>/</b>			
1.000	1.000 +/-0.010		<b>\</b>			
0.250	+/-0.010	6.249	ン			
0.061	+/-0.010	0.061	\ \			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	00.231x0.125	<b>\</b>			
			<u></u>			
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·						_
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Measured by:	H.A	Audited by:	80	Prototype Approval:	N/A
Date:	69/11/27	Date:	09/11/24	Date:	N/A

Rev	Date	Change		<u> </u>	Revised by	Approved
A	06.08.30	New Issue	P/O D2873-045		KJ/JLM	
		·			- 70	

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